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3. That the attached is, to the best of RWS Group Ltd knowledge and belief, a true translation into the English language of the accompanying copy of the specification filed with the application for a patent in France on January 15, 2003 under the number 03/00,380 and the official certificate attached thereto.
4. That I believe that all statements made herein of my own knowledge are true and that all statements made on information and belief are true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the patent application in the United States of America or any patent issuing thereon.



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PATENT UTILITY CERTIFICATE

Intellectual Property Code - Book VI



BR1

REQUEST FOR GRANT

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3 TITLE OF THE INVENTION (200 characters or spaces maximum)			
HEAT EXCHANGER FOR FIBERIZING BOOTH			
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DATE 15 JAN 2003

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6 REPRESENTATIVE

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7 INVENTOR (S)

The inventors must be natural persons

The inventors are the applicants

☐ Yes

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C. TRAN

The present invention relates to improvements made to fiberizing booths intended for the fabrication of glass filaments. It will be recalled that a fiberizing booth is, in a way known per se, made up of at least
5 one bushing pierced with a plurality of holes through which molten glass flows to form a web of glass filaments.

More specifically, the present invention is aimed at a heat exchanger device designed to be positioned
10 underneath the bottom of the bushing, the latter being itself situated within the fiberizing booth.

Now, operating a fiberizing booth is actually a particularly complex process in the course of which numerous physico-chemical parameters are constantly
15 monitored. In this respect, it is pointed out in particular that the temperature at the bottom of the bushing is one of the most important parameters in obtaining an optimum filament as it is actually this that governs the viscosity of the glass.

20 To this end, it is therefore necessary to cool the underside of the bushing so as to set the temperature of the cones of glass fibers.

Furthermore, other phenomena influence the temperature of the cone of filaments and require the
25 incorporation of heat exchanger devices underneath the bottom of the bushing.

Thus, in a fiberizing booth, the movement of the filaments carries along the air trapped in the web toward the outside of the booth, and this causes air to
30 be sucked from the outside toward the inside of the web underneath the bottom of the bushing. It is necessary to supply fresh air to compensate for this lack of air underneath the bottom of the bushing so as to ensure uniform heat exchange with the glass cones and the
35 bottom of the bushing, thus making it possible to improve the uniformity of the filament thickness.

A first family of known heat exchanger devices

which are able to influence the temperature at the bottom of the bushing but do not perform the air supply function consists of an array of fins forming combs. Each of the fins is made of a bar made of a material
5 with excellent heat exchange coefficients (particularly in terms of conduction), one of the free ends of each bar being connected to a manifold secured to the fiberizing booth at the underside of the bushing and provided with a heat transfer circuit thus allowing the
10 heat energy extracted by conduction to be taken away, the glass filaments passing between the gaps of the comb.

Although it meets the current requirements in terms of the cooling of the underside of the bushing,
15 this first family of devices cannot be read across to bushings with a high throughput. Problems associated with the geometry of the fiberizing booths (the dimensions of the area of the booth intended to accommodate the bushing are set by construction) make
20 it difficult to envisage mounting these devices on bushings comprising a great many (several thousand) orifices, this problem being all the more exacerbated when, in addition, additional air needs to be supplied, something that is essential in high-throughput
25 bushings.

Also known is a second family of heat exchanger devices which perform both the function of cooling the cone of glass and the function of supplying air. These are blowing fins. The latter are also configured as a
30 comb and situated underneath the bottom of the bushing, the glass filaments passing through the gaps between the rows of fins.

Cooling fins are known from patents US 3 150 946 and US 3 345 147. Now, according to those documents,
35 the fins are made from a metal gauze which is folded into a tube to form the fin. However, folding deforms some of the holes in the mesh. These are then no longer

the same size and the flow generated by blowing is no longer uniform.

Patent US 5 693 118 discloses a suction fin device that increases the convected heat exchange underneath
5 the bottom of the bushing. The sucking of air through the fins generates uniform flow under the bushing and improves the stability of the fiberizing. By contrast, the sucking-in of air through the fins encourages the deposition of airborne substances (dust) on the surface
10 of the fins and the ingress of dust and water droplets into the web, and these are factors known to contribute to the instability of the web.

Patents US 4 214 884 and US 4 310 602 relate to fins made from a thin sheet of solid nickel. The holes,
15 with identical and precise dimensions, are obtained using a photochemical or electrolytic process.

In spite of the care taken in manufacturing these holes, their density is not enough to guarantee the optimum air flow conditions (uniformity) that will
20 guarantee the stability of the web of glass filaments.

The present invention therefore aims to alleviate these disadvantages by proposing a heat exchanger device intended to be positioned underneath the bottom of a bushing, particularly a high-throughput bushing,
25 this heat exchanger device being designed to guarantee optimum fiberizing conditions for the web of filaments passing through said bushing.

To this end, the heat exchanger device that is the subject of the invention, comprising at least one fin
30 provided with means for blowing a fluid, is characterized in that the blowing means consist of at least one of the walls of said fin, said wall having open porosity.

By virtue of these arrangements it is possible to
35 obtain optimum cooling of the cone of glass leaving the bottom of the bushing using a convection movement resulting from the blowing of the fluid.

In preferred embodiments of the invention recourse may also possibly be had to one and/or other of the following measures:

5 - the open porosity of the wall is between 5 and 30% and preferably between 10 and 25% and more preferably still between 15 and 20%,

10 - the fin is of parallelepipedal overall shape and tubular cross section and has a permeability measured with air at a pressure of 0.5 bar and at 0°C lying in the range from 300 to 800 Sm³/h/m², and preferably lying in the range between 500 and 600 Sm³/h/m²,

 - the blowing fluid velocity field is symmetric across the open porosity wall,

15 - at least one of the walls of the heat exchanger device is obtained by sintering a metal powder,

 - the metal powder is based on a mixture of powdered stainless steel with a particle size smaller than 100 µm and preferably with a particle size lying within the range from 10 to 80 µm,

20 - the porosity of the fin based on metal powder is of the order of 17%,

 - at least one of the walls of the heat exchanger device is obtained by laminating a metal gauze,

25 - the lamination comprises 3 to 6 layers of the metal gauze,

 - the fluid is air at a pressure of between 0.1 and 6 bar, preferably between 0.2 and 4 bar,

30 - the blowing fluid results from the vaporization within the fin of a fluid that was initially in the liquid state,

 - the heat exchanger device is provided with an auxiliary cooling circuit.

35 Other features and advantages of the invention will become apparent in the course of the following description of one of its embodiments, given by way of non-limiting example with reference to the attached drawings. In the drawings:

- Figure 1 is a perspective view of a heat exchanger device according to the invention,

- Figure 2 is a curve illustrating the change in throughput of a bushing as a function of the increase
5 in the set point temperature of the bushing,

- Figure 3 is a curve illustrating the change in thermal power likely to be removed by a blowing fin as a function of the blowing fluid flow rate,

- Figures 4 and 5 are photographs illustrating the
10 change in shape of the cone for various blowing fluid temperatures and flow rates.

Figure 1 depicts the heat exchanger device 1 according to the invention. This device essentially comprises a plurality of fins 2 (to make the drawing
15 easier to understand, just two fins have been depicted) and a manifold 3. Each of the fins, at one of its free ends, is secured by known means (welding, brazing, bonding) to one of the walls of the manifold so as to form a comb.

20 This comb is intended to be positioned underneath and near the bottom of a bushing in a fiberizing booth. The spacing between the fins corresponds roughly to the separation of the fiberizing nozzles situated at the bottom of the bushing so that the filaments of molten
25 glass pass more or less in a plane positioned such that it is coplanar with and equidistant between two juxtaposed fins.

Each fin is of roughly parallelepipedal shape with a tubular cross section and has short and long walls 4,
30 5 parallel to one another in pairs, the long walls 4, 5, however, being intended to face the filaments. In the example depicted in Figure 1, the fin is of rectangular cross section and the interior passage 6 defined between the walls 4, 5 of the fin allows a
35 compressed blowing fluid (such as air or nitrogen for example) to pass. This blowing fluid is subjected beforehand to a treatment to remove any harmful

particles which might tend to clog the pores of the fin (air from which oil and dust have been removed). The blowing fluid may also result from the vaporization of a fluid initially in the liquid state (water, alcohol, ethylene glycol, acetone, this fluid being used pure or as a mixture), this vaporization taking place within the fin: this type of blowing fluid is advantageous because it makes it possible to use the latent heat of vaporization of the fluid. Each of the passages of each of the fins is connected to the manifold when the comb is produced, the comb itself being provided at the manifold with a device for connection to the blowing fluid distributed to the fiberizing booth.

According to a first embodiment of the invention, the fin is obtained by sintering a metal powder, particularly a mixture of powdered stainless steel, the particle size of which is smaller than $100\text{ }\mu\text{m}$ and preferably lies in the range from 10 to $80\text{ }\mu\text{m}$.

The open porosity sought with this type of powder is in the range between 5 and 30% and preferably between 10 and 25% and more preferably still between 15 and 20% and more or less around 17%.

The thickness of the tubular walls of the fin is more or less around 1 mm.

Using these fins it has been possible to measure, across each to the long faces of the fin, a permeability to air measured at 0.5 bar and 0°C in the range from 300 to $800\text{ Sm}^3/\text{h}/\text{m}^2$ and preferably in the range from 500 to $600\text{ Sm}^3/\text{h}/\text{m}^2$, which represents flow speeds of between 0.08 and 0.2 m/s in the case of the first range of permeability values. The operating pressure of the fin and therefore of the comb which incorporates at least one of these fins is between 0.1 and 6 bar, preferably between 0.2 and 4 bar.

According to a second embodiment, the fin is obtained by laminating a metal gauze, between at least 3 and 6 layers of gauze assembled by compression or by

sintering. The mesh size of the gauze lies more or less in the range from 1 to 30 μm .

The open porosity sought with this lamination of metal gauze lies in the range from 5 to 30 % and preferably between 10 and 25% and more preferably still between 15 and 20%.

Likewise, using these fins, it has been possible to measure on each of the long faces of the fin a permeability to air at 0.5 bar and at 0°C in the range from 300 to 800 $\text{Sm}^3/\text{h}/\text{m}^2$, preferably in the range from 500 to 600 $\text{Sm}^3/\text{h}/\text{m}^2$, which represents flow speeds of between 0.08 and 0.2 m/s (in the case of the first range of permeability values). The operating pressure of the fin and therefore of the comb incorporating at least one of these fins is between 0.1 and 6 bar, preferably between 0.2 and 4 bar.

Using this method of fabrication it has been possible to determine a certain number of characteristics regarding the flow of the blowing fluid through each side of the long walls of the fin.

Hence, Figure 2 shows the change in throughput of the bushing as a function of the increase in the set point temperature of the bottom of the bushing for various blowing fluid flow rates through a wall of the fin. The data relating to the bushing illustrated in Figure 2 *et seq.* are given by way of indication, the bushing in question being a laboratory bushing fed with alkali-resistant glass cullet.

The throughput of the bushing increases progressively as the bushing set point temperature increases. At the maximum temperature (1475°C) that the bushing can withstand, by adjusting the blowing flow rate a maximum bushing throughput of 47.2 kg/day is observed. This is 21% higher than the maximum throughput that can be achieved with conventional fins (39.1 kg/day). The gain in throughput using the blowing fins is therefore very great. It should be pointed out

that this maximum throughput is limited rather by the maximum set point temperature of the bushing (1475°C) at which temperature the alloy of which the bushing is made melts.

5 The increase in the throughput of the bushing is not only dependent on the temperature of the blowing fluid, which provides cooling of the fins by convection. When the blowing fluid passes through the porous walls of the fins, the fresh blown fluid
10 (entering the fins at 20°C) efficiently cools the fins and is able to keep the fin temperature relatively low dependent on the blowing flow rate. This low temperature of the blowing fins allows at the same time an increase in the radiation heat exchange between the
15 cones and the blowing fins. In order to give an idea of the cooling capability of the blowing fins, Figure 3 sets out the thermal power that can be removed by a blowing fin as a function of the blowing fluid flow rate, assuming an air temperature around the cones of
20 100°C, 200°C and 300°C, respectively. It can be pointed out that, if a fin blows a blowing fluid (in this instance air) at a flow rate of 5 m³/h, it is able to remove 120 W at 100°C, 280 W at 200°C and 450 W at 300°C. This data should be compared with the cooling
25 capability of a fin known from the prior art, the latter cooling capability being limited to around 100 watts.

Although increasing the throughput of a bushing is one of the users' main objectives it is nevertheless
30 important not to lose sight of the fact that this increase must not be had at the expense of the stability of the bushing, and mainly the stability of the cones formed underneath the bottom of the bushing. Now, cone stability is dependent on the cone
35 temperature, this temperature itself being dependent on the flow rate of the blowing fluid and on its homogeneity.

As can be seen in Figures 4 and 5, it is observed that when the set point temperature increases the cone depicted in Figure 4 becomes increasingly hot. It progressively regains its volume and becomes increasingly straight. In the case of the cone depicted in Figure 5, the blowing by the fins is more gentle and the cone is wider. When the set point temperature increases, the cone enlarges and begins to spill over around the nozzle. Upwards of 1465°C, the air flow rate has to be increased in order to stabilize the fiberizing. An extremely advantageous phenomenon is observed: the cone is very stable and there is practically no longer any of the pulsation of the cone that is found with fins of the prior art. Fiberizing can be achieved stably even when the cone spills over around the nozzle. When the cone is extremely hot, pulsation reappears and a small increase in blowing is immediately able to calm this instability. In addition, during tests, it was found that the shape of the cones could very easily and very flexibly be varied by altering the flow rate blown through the fins. This offers the advantage of a great potential for adjusting the thickness of the filament.

Of course, other embodiments not depicted in the figures may be conceived of, particularly in terms of the shapes, cross sections and outlines of the fins. Likewise, in terms of the heat exchanger device and according to an alternative form, also not depicted in the figures, provision is made for a cooling circuit to be incorporated in the manifold in order to remove additional heat energy by circulating a heat transfer fluid (such as water for example).

The invention described above offers numerous advantages:

- It increases the cooling of the cone of glass and the bottom of the bushing by the blowing of the fins. This makes it possible to widen the

fiberizing temperature range. Fiberizing becomes less critical and more stable;

- It avoids the deposition of airborne substances on the surfaces of the fins by blowing. It makes it possible to provide fins that are more efficient and more economical for the fiberizing of glass filaments. The production of filaments can thus mainly or entirely dissociate itself from the disruption of periodic cleaning of the fins, thus improving productivity;
- It provides fins the heat absorption rate of which can be adjusted, allowing optimum heat absorption under all operating conditions;
- It supplies an additional means for precisely adjusting the thickness of the filaments by adjusting the blowing pressure;
- It immediately, using fresh air blown through the fins, compensates for the air sucked out of the fiberizing region by the drawing of the filaments, making it possible to reduce or prevent the ingress of air from the outside toward the inside of the web of filaments in this sensitive region. Fiberizing can thus dissociate itself from the effects of turbulent or transient disturbances in the flow of air outside the web of filaments (for example: the movement of dust). The air flow conditions in the fiberizing region become more stable and easier to control.

CLAIMS

1. A heat exchanger device (1) comprising at least one fin (2) provided with means for blowing a fluid, characterized in that the blowing means consist of at least one of the walls (4, 5) of said fin (2), said wall (4, 5) having open porosity.
2. Heat exchanger device (1) as claimed in claim 1, characterized in that the open porosity of the wall (4, 5) is between 5 and 30% and preferably between 10 and 25% and more preferably still between 15 and 20%.
3. Heat exchanger device (1) as claimed in one of claims 1 and 2, characterized in that the fin (2) is of parallelepipedal overall shape and tubular cross section and has a permeability measured with air at a pressure of 0.5 bar and at 0°C lying in the range from 300 to 800 Sm³/h/m².
4. The heat exchanger device (1) as claimed in claim 3, characterized in that the permeability measured with air at a pressure of 0.5 bar and at 0°C lies in the range from 500 to 600 Sm³/h/m².
5. The heat exchanger device (1) as claimed in one of claims 1 to 4, characterized in that the blowing fluid velocity field is symmetric across the open porosity wall.
6. The heat exchanger device as claimed in one of claims 1 to 5, characterized in that at least one of the walls (4, 5) of the heat exchanger device is obtained by sintering a metal powder.
7. The heat exchanger device (1) as claimed in claim 6, characterized in that the metal powder is based on a mixture of powdered stainless steel with a particle size smaller than 100 μm and preferably with a particle size lying within the range from 10 to 80 μm.

8. The heat exchanger device (1) as claimed in claim 7, characterized in that the open porosity is of the order of 17%.
- 5 9. The heat exchanger device (1) as claimed in one of claims 1 to 5, characterized in that at least one of the walls of the heat exchanger device is obtained by laminating a metal gauze.
- 10 10. The heat exchanger device (1) as claimed in claim 9, characterized in that the lamination comprises 3 to 6 layers of the metal gauze.
11. The heat exchanger device (1) as claimed in any one of the preceding claims, characterized in that the fluid is air at a pressure of between 0.1 and 6 bar, preferably between 0.2 and 4 bar.
- 15 12. The heat exchanger device (1) as claimed in any one of claims 1 to 10, characterized in that the blowing fluid results from the vaporization within the fin (2) of a fluid that was initially in the liquid state.
- 20 13. The heat exchanger device (1) as claimed in any one of the preceding claims, characterized in that the heat exchanger device is provided with an auxiliary cooling circuit.

Figure 1

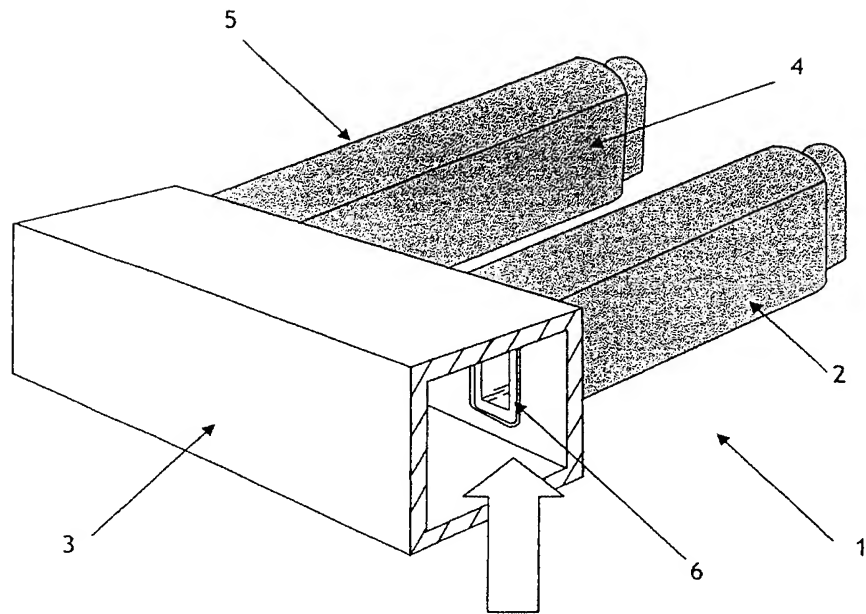


Figure 1

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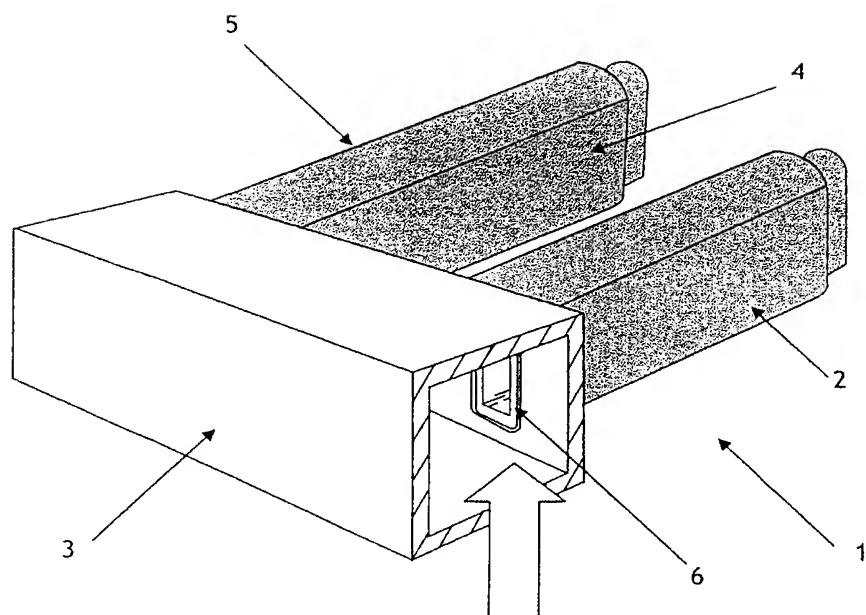


Figure 1

Figure 2

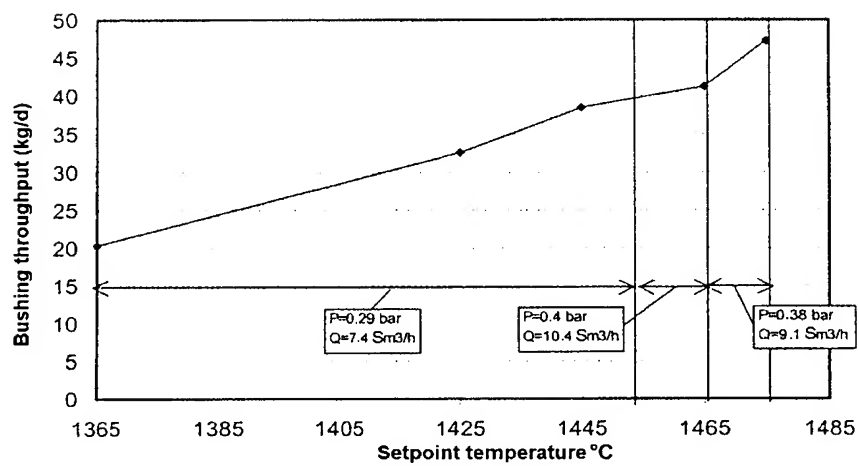


Figure 2

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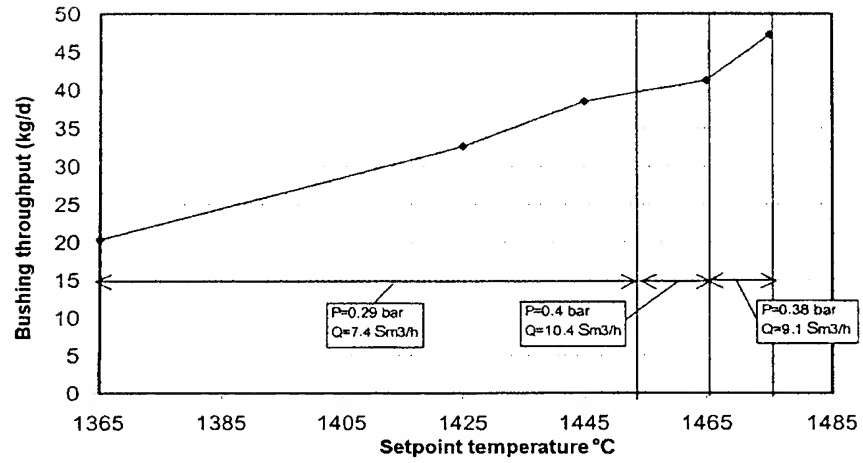


Figure 2

Figure 3

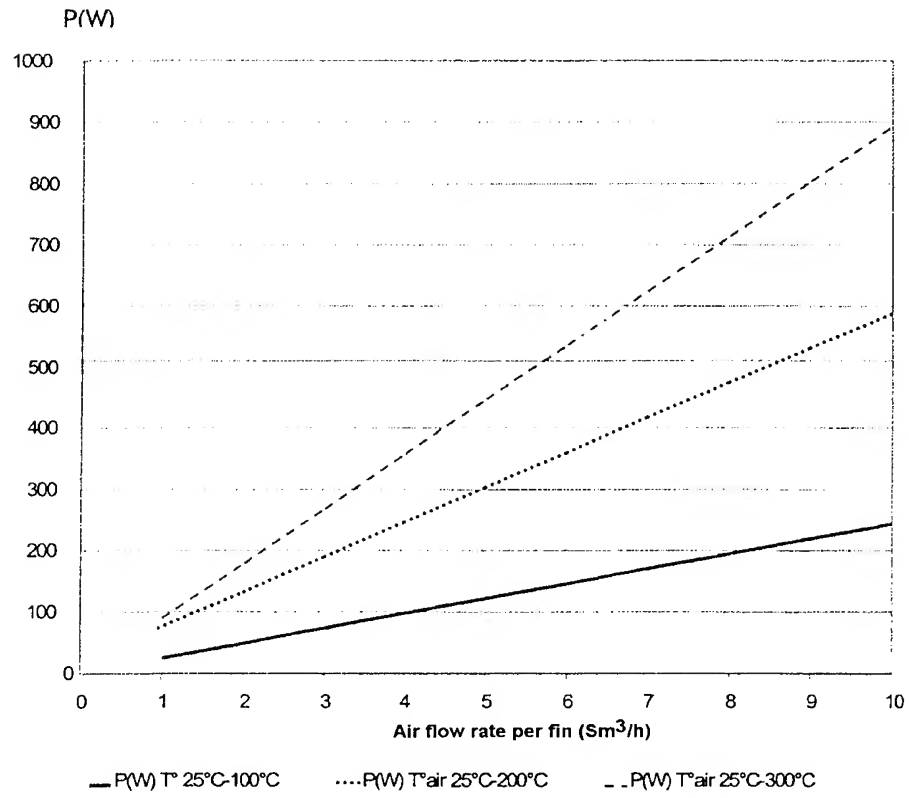


Figure 3

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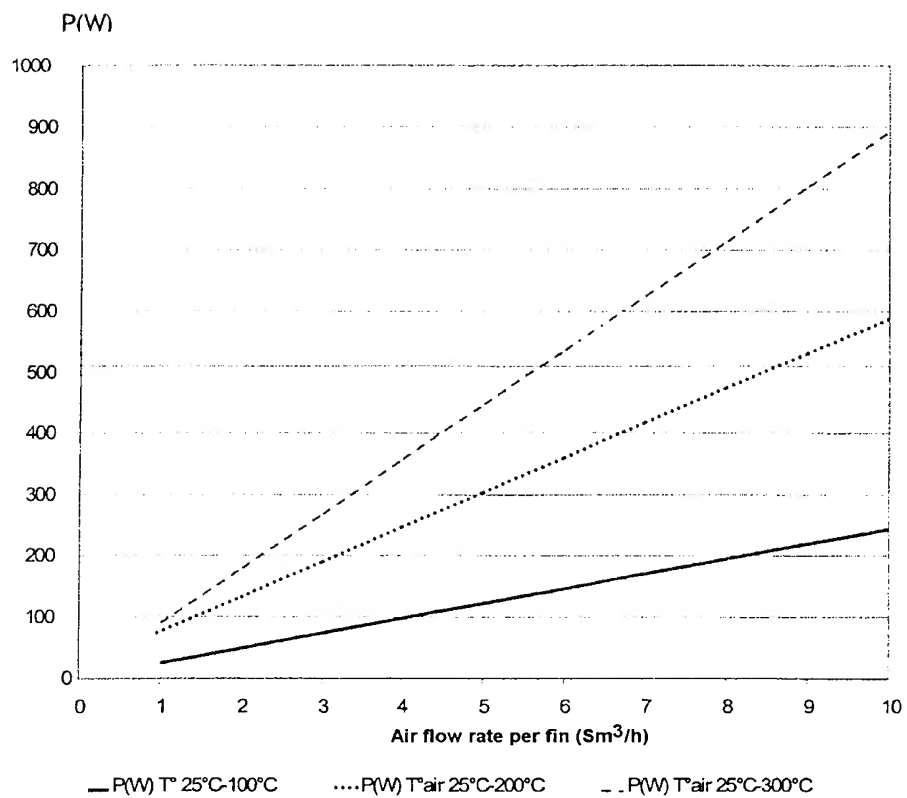
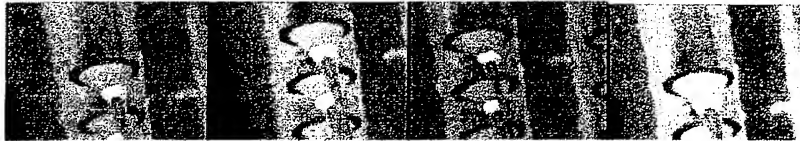


Figure 3

Figure 4



T_setpoint :	1365°C	1385°C	1405°C	1425°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h



T_setpoint :	1445°C	1455°C	1465°C	1475°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	10.4 Sm ³ /h	9.1 Sm ³ /h

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T_setpoint :	1365°C	1385°C	1405°C	1425°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h



T_setpoint :	1445°C	1455°C	1465°C	1475°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	10.4 Sm ³ /h	9.1 Sm ³ /h

Figure 5



T_setpoint :	1365°C	1385°C	1405°C	1425°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h



T_setpoint :	1445°C	1455°C	1465°C	1475°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	10.4 Sm ³ /h	9.1 Sm ³ /h

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T_setpoint :	1365°C	1385°C	1405°C	1425°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h	7.4 Sm ³ /h



T_setpoint :	1445°C	1455°C	1465°C	1475°C
Q_blowing :	7.4 Sm ³ /h	7.4 Sm ³ /h	10.4 Sm ³ /h	9.1 Sm ³ /h